

Work Order ID 64298

Wednesday, December 01, 2010 2:49:09 PM

Page 1

Item ID: D350-578-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw

Start Date: 12/1/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 12/10/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2432	Rev F3

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-011 CHG005 *

8/10/12/08

10-12-1 (10)

160

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/12/17 (92) SP

170

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/10/12/08

(49)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 12/1/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 12/10/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-011 □ Location: 11*Leva**10/12/08**(9)*

190

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

*10/12/08**2/10/08*
(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist-Print

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Work Order ID: 64298

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 12/1/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-17A Bolt		Purchased	No			160	Each	242.0000	12	120/108 10/12/08			
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Location	Loc Qty	Loc Code
ST359	242	

D2182B Rubber Cushion		Manufactured	No	112314		160	f	280.6600	2.5	108 25 22.5 10/12/08			
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Location	Loc Qty	Loc Code
ST410	280.66	
63413	280.66	

Cut qty 6 at 5.00" long D2274 Radius Block		Manufactured	No			160	Each	13.0000	12	120/108 10/12/08			
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Location	Loc Qty	Loc Code
ST010	13	
59108	12	
61361	1	

D2432 206 (24") Bearpaw		Manufactured	No			160	Each	2.0000	2	20 63775 16 x B 63279 2x 10/12/08			
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Location	Loc Qty	Loc Code
ST495	2	
63279	2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 64298

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 12/1/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

D2438

Manufactured No

160 Each

103.0000

6

Clamp

LocationLoc QtyLoc Code

ST456

103

60852

103

Manufactured No

160 Each

1,120.000

12

D2529

Washer

LocationLoc QtyLoc Code

ST017

1120

58568

15

61979

105

64127

1000

Purchased No

160 Each

5,185.000

12

MS21042L4

Nut

LocationLoc QtyLoc Code

ST300

5185

1123143

2

115589

583

115621

1100

116188

3500

Purchased No

160 Each

2,360.000

24

NAS1149D0463J

Washer

LocationLoc QtyLoc Code

ST298

2360

110914

4

115622

38

116025

118

116289

2200

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

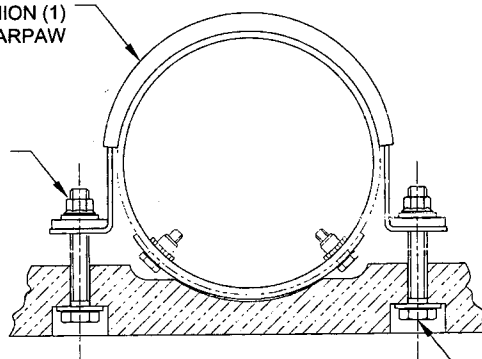
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

D2438 CLAMP (1)
D2182B050 RUBBER CUSHION (1)
3 PL PER BEARPAW

MS21042L4 NUT (1)
AN960JD416 WASHER (1)
D2274 RADIUS BLOCK (1)
D2529 WASHER (1)
AN4-17A BOLT (1)
6 PL PER BEARPAW



ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

REFERENCE ONLY

Section A-A
Figure 4 - Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)

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Revision: F
Date: 08.08.28